

Work Order ID 86310

86310

Page 1

June-26-12 3:41:19 PM

Item ID: D3688-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: STUD

Stop ***NS2***

Start Date: 26/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/27 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3688	Rev C								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	***DO NOT USE CHOP SAW***								
				SL 12-08-09					
110	DOOSAN LATHE	0.00							
110									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA718 Rev: _____ & Dwg D3688 Rev: <u>C</u> 2-Deburr per dwg D3688								
	3-Check .625" bore with DT9530 GO/NO GO Gauge								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
				SL 12-08-09					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86310

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Page 2

Item ID: D3688-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: STUD

Start Date: 26/06/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC8- Inspect parts - second check 0.00

170

QC

Quality Control

Memo

100% CHECK, CHECK ALL DIMENSIONS AND THREAD FIT

180 PURCHASING 0.00

180

Purchasing

Purchasing

Memo

Issue P/O: 17684 LPI Per ASTM 1417 LEVEL
2Certificate of conformaty is required

190 Receive & Inspect for Damage & Mat'l Certs 0.00

190

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

DAS 16 12/08/10

CZ 12/08/13 (2)

St 12/08/13

2x 8p 12-8-13

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 10/07/2012 Req'd Qty: 2.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00	SMB	12-8-13	DAS 16	2			
Quality Control									
210	Identify as per dwg & Stock Location <u>CA</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MUS 12/08/14

R12-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-26-12 3:41:23 PM

Page 1

Work Order ID: 86310

86310

Parent Item: D3688-1

D3688-1

Parent Item Name: STUD

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC
IPP REV:D 10.07.06 revo step 130-160 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No			100	f	80.3130	1.087	2.288421			

M174PH-H900R1 000

17-4SS H900 ROUND BAR 1.00

**

2120809

Location

Loc Qty

Loc Code

MAT030

80.313

117445

1.23

120767

11.75

121280

35

121918

32.333

2.3

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86310
Description: Stud		Part Number:	D3688-1
Inspection Dwg: D3688	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.695	/		Vern	JL-10
0.625	+0.004/-0.000	.626	/		Vern JL-10	DT 9530
1.25	+0.000/-0.03	1.236	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	.045	/			
0.11 Ref	+/-0.030	.11	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.189	/			
1.31	+/-0.030	1.315	/			
1.65	+/-0.030	1.650	/			
0.870	+0.000/-0.010	.865	/			
Ø0.659	+0.000/-0.015	.653	/			
11.573	+/-0.015	11.574	/		Vern	CNC-02
2.90	+/-0.030	2.880	/			
3/4-16UNF-2A	N/A		/			
0.075 x 45°	+/-0.010 x 0.5°	.08x45°	/			
0.370	+0.000/-0.010	.366	/			
Ø0.189	+0.005/-0.001	.189	/			
R0.25	+/-0.030	.25	/			
R0.50	+/-0.030	.50	/			

Measured by:	JL	Audited by:	DAU	Prototype Approval:	N/A
Date:	12-08-09	Date:	16-09-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	

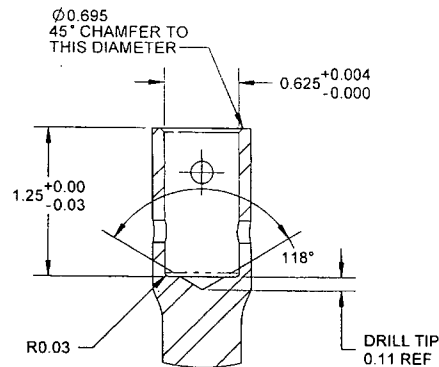
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

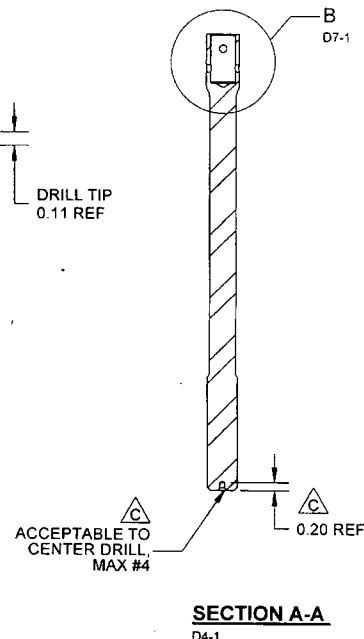
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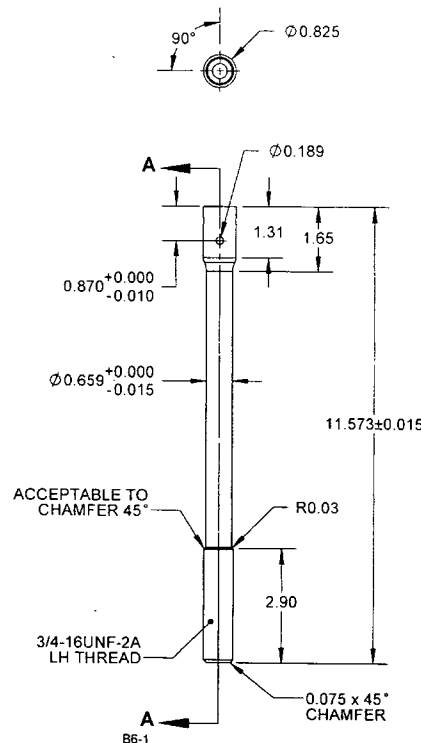
NOTE: Date & initial all entries



DETAIL B
SCALE 3X
D6-1



SECTION A-A
D4-1



D3688-1 STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.24 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-09-22

C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B6-3, B6-4); UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A8-4); REDUCE LENGTH ON D3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTOTYPE INSTALL; Ø0.695 WAS Ø0.665 (ZN D8-1, D8-2, D8-3); Ø0.508 WAS Ø0.478 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. C
MFG APPR.	97	D3688	SHEET 1 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	STUD	NTS
DATE	09.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

80310 MLJ

12/06/27.

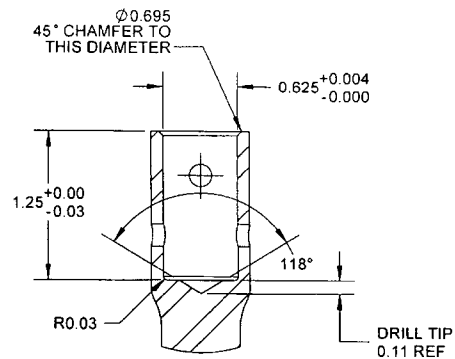
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

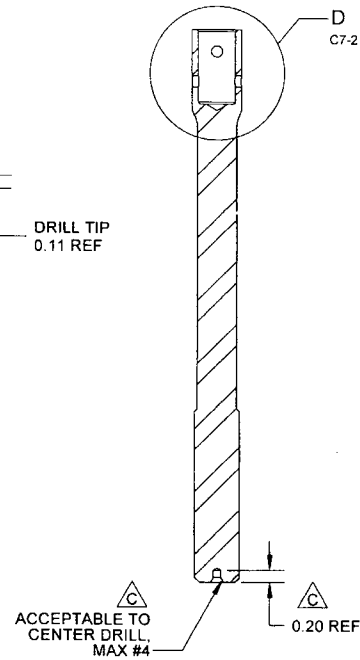
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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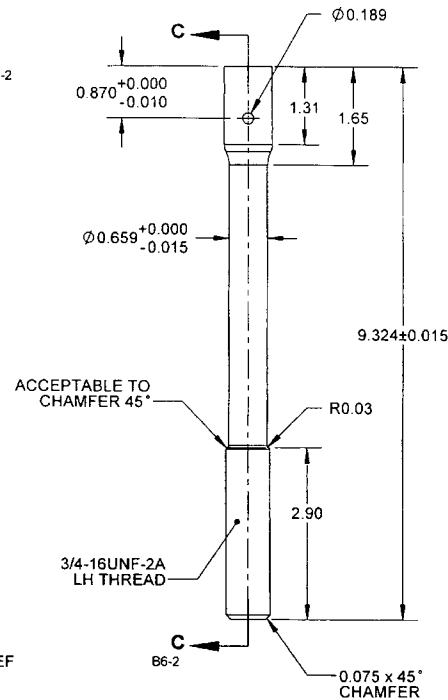
NOTE: Date & initial all entries



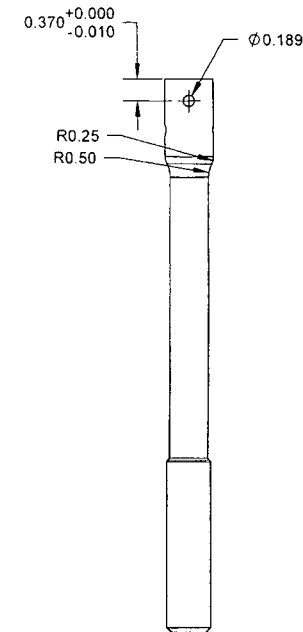
DETAIL D
SCALE 2X
D6-2



SECTION C-C
D4-2



D3688-3 STUD



RELEASED
2009-09-22
JWW

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3688	SHEET 2 OF 4
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DE APPR.	JP	STUD	NTS
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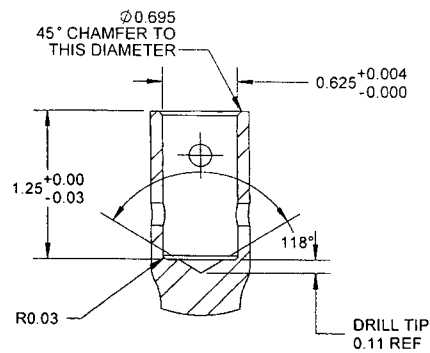
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

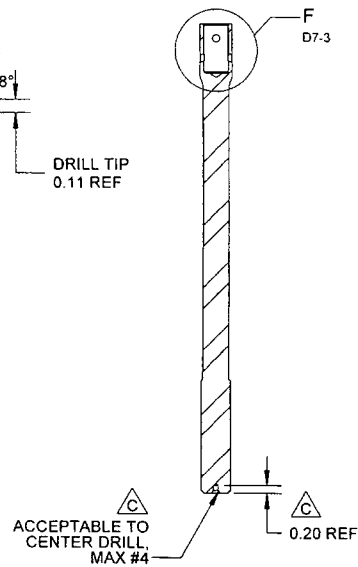
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

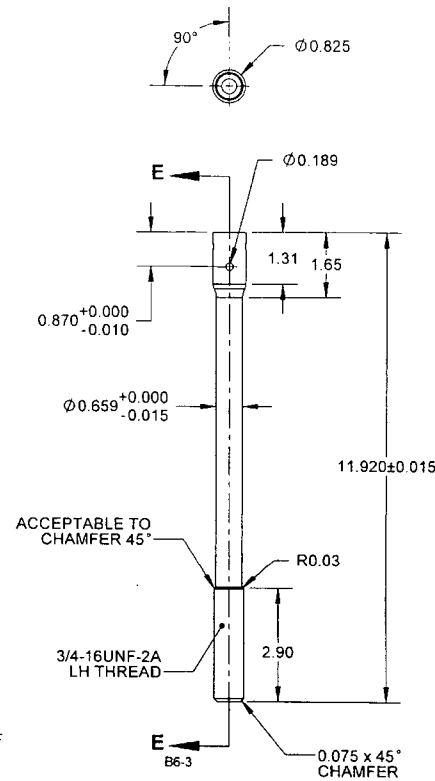
NOTE: Date & initial all entries



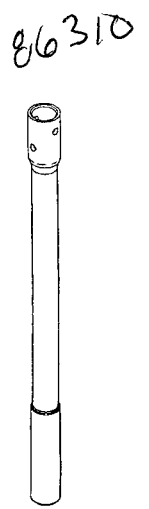
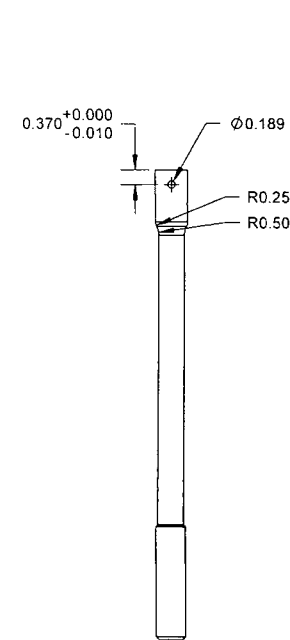
DETAIL F
SCALE 3X
D6-3



SECTION E-E
D4-3



D3688-5 STUD



NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-09-22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D3688	SHEET 3 OF 4
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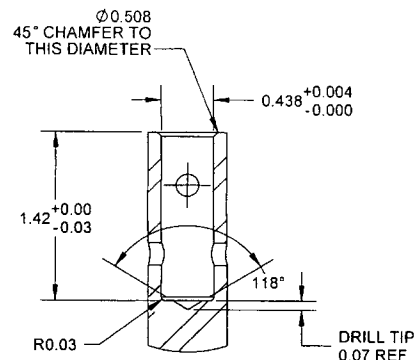
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

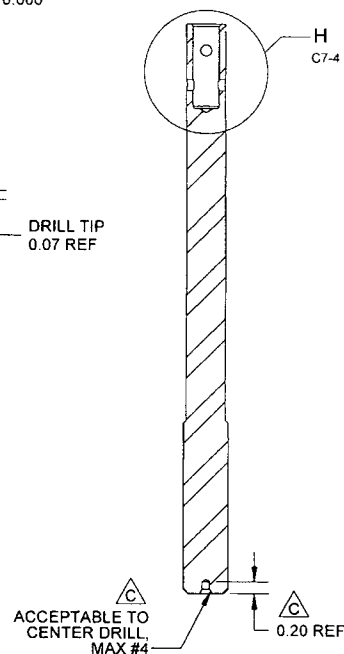
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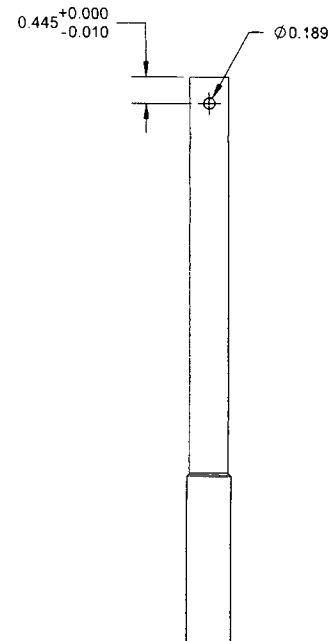
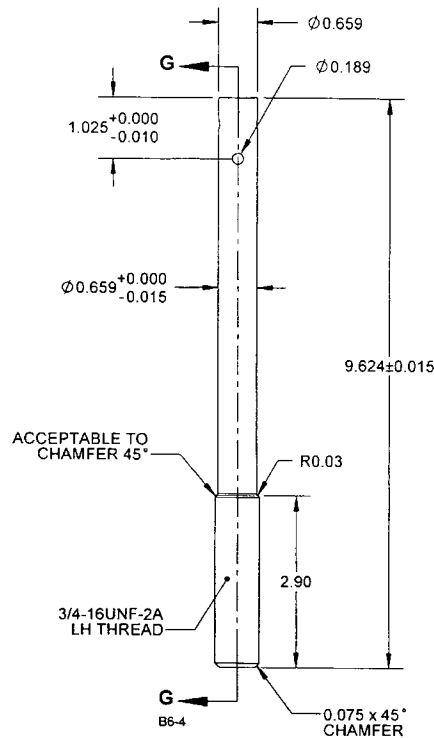


DETAIL H
SCALE 2X
D6-4



SECTION G-G
D4-4

D3688-7 STUD



86310

RELEASED
2009-09-22

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.97 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12195

CLIENT	DAT AREOSPACE	DATE	August 10/12	PAGE	1	OF	1	
ATTENTION	LINDA / MAT.	ACUREN JOB NO.	100-12-00309	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ARDEN ST. HAWKESBURY, ON.	PO/NO.		WORK LOCATION	SAME -			
PROJECT	CROSS TUBES, MACHINED STUDS			ACCEPTANCE STD.	ASTM 1417 101-038			
ITEM(S) EXAMINED	(6)			REV./DATE	2005			

JOB DESCRIPTION	PROCEDURE NO.	LT 1002	REV./DATE	2008	TECHNIQUE NO.	LT 1002	REV./DATE	2008	
PART NO.	SEE RESULTS			MATERIAL	ALUMINUM / STAINLESS STEEL			THICKNESS	VARIABLE
SCOPE	A WET FLOUR TEST LIQUID PENETRANT EXAMINATION WAS COMPLETED ON THE SURFACE ONLY 100%								

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAGNA FLUX
PENETRANT	2LG7 MINIMUM DWELL TIME 10 MIN.
PENETRANT REMOVER	H2O MINIMUM DRY TIME 10 MIN.
DEVELOPER	1KD52 MINIMUM DWELL TIME 10 MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED	
BLACK LIGHT S/N 16459 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc	
LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
OTHER	
LIGHT METER S/N 1098866 CAL DUE DATE Aug 13/12	

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS- (<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL)			
ITEM	COMMENTS	ACCEPT	REJECT
2 - STUDS - W.O. # 86310		/	5/20/13
1 - CROSSTUBES - W.O. # 88044		/	
1 - " " " # 80048		/	
1 - " " " # 88045		/	
1 - " " " # 84779		/	
1 - " " " # 85562		/	
1 - " " " # 87295		/	
REGARD AN AREA FOR INDICATIONS			

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES			
CLIENT REPRESENTATIVE	JESSE WHITE	DTR #	E 91565
TECHNICIAN (SIGNATURE):	Mike Plush	REPORT REVIEWED BY:	
NAME (PRINT):	Mike Plush	NAME	INITIALS
CGSB LEVEL	II SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No	6606	CGSB REG. No	